

Date: Friday, 18/07/2008 2:14:50 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR ARM
Job Number :	40667		
Estimate Number :	10505		
P.O. Number :		Part Number :	D2010103
This Issue :	18/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2010 REVD
First Issue :	1/1	Project Number :	N/A
Previous Run :	39822	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.7.18</u>	Due Date :	25/07/2008
Comment :	Est : F 02.08.21 Re-format; Added D2057 KJ/RF Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC Est Rev:H 08-06-20 rev.D as per dwg DD verified by:EC		

Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W049	304 RD Tube .500 x .049W



Comment: Qty.: 1.5750 f(s)/Unit Total : ~~47.2500 f(s)~~ 80
 Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall
 (M304TR0500W049) Batch No: M 108 324 50 08/07/23 (50)

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: BRAKE NC
 Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727
 Identify as D2010-103 50 08/07/23 (50)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Bend as per Dwg D2010 using bending Jig D2010-103T2
 2- Deburr ends FF 08-07-24 50 08/07/23 (50)

4.0	D2057	Plug
-----	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Plug
 Pick:

Qty	Part Number	Description	Batch
1	D2057	Plug	<u>B40048</u>

FF 08-07-24 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/07/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 2:14:51 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 40667

Part Number: D2010103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-flare before installing plug as per dwg D2010

2-Install D2057 plug as per Dwg D2010

FF 08-07-24

(50)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24 (X50) counts

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40 OF
3:20
9:10

M-1 / 08/07/26

(50X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

KS 08/07/28 (X50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 23 (overstaked) 08/07/28 (X50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D08107/28

Job Completion



mf 08-07-28

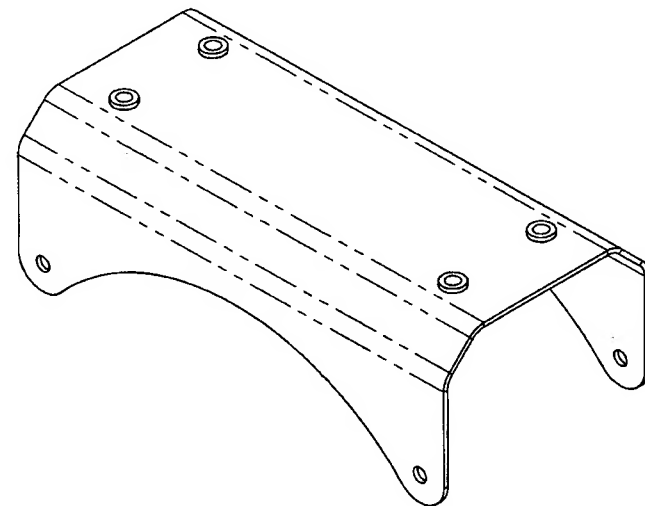
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

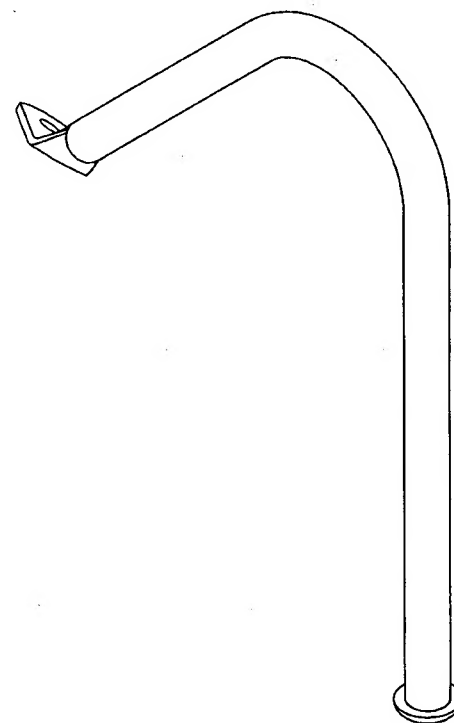
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

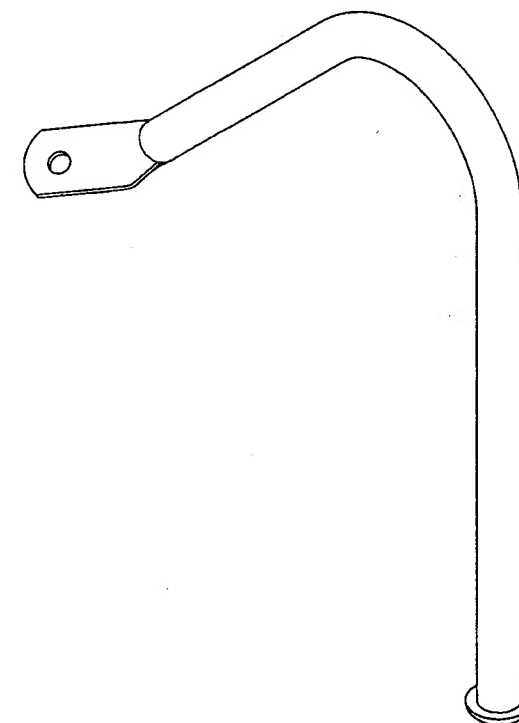
NOTE: Date & initial all entries



D2010-101 MIRROR BRACKET



D2010-103 ARM



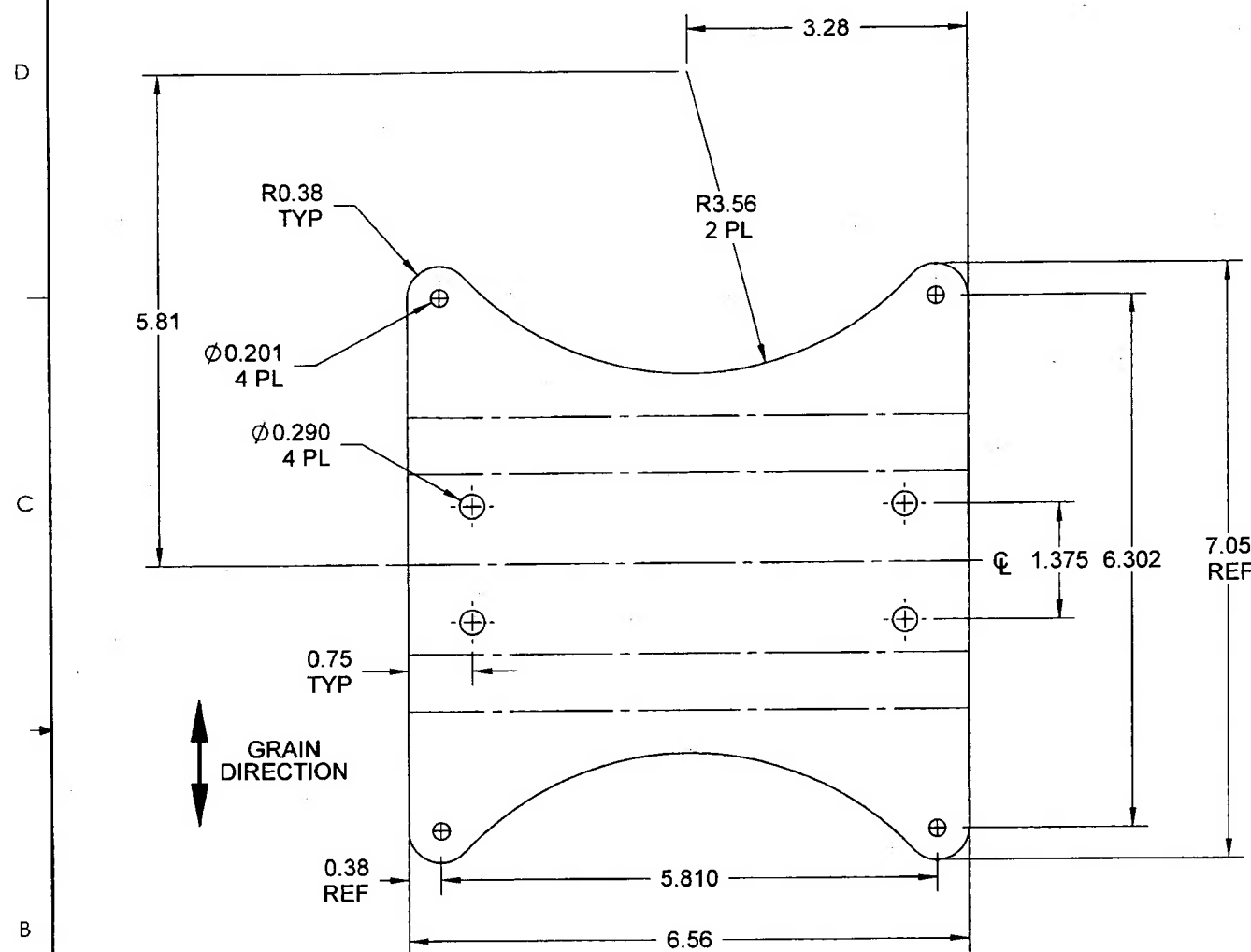
D2010-104 ARM

RELEASED
08.06.10

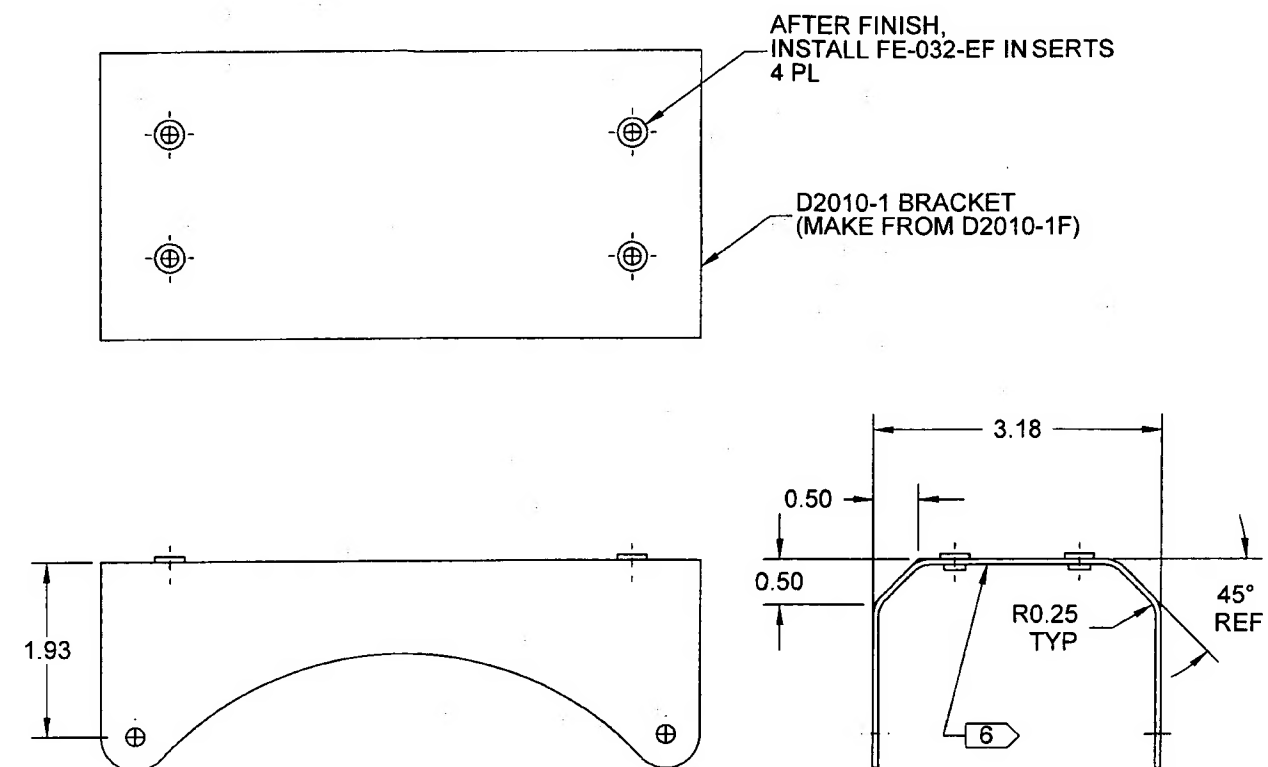
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40007

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON; TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
DATE	08.06.10	<small>COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



D2010-1F FLAT PATTERN



D2010-101 MIRROR BRACKET

NOTES:

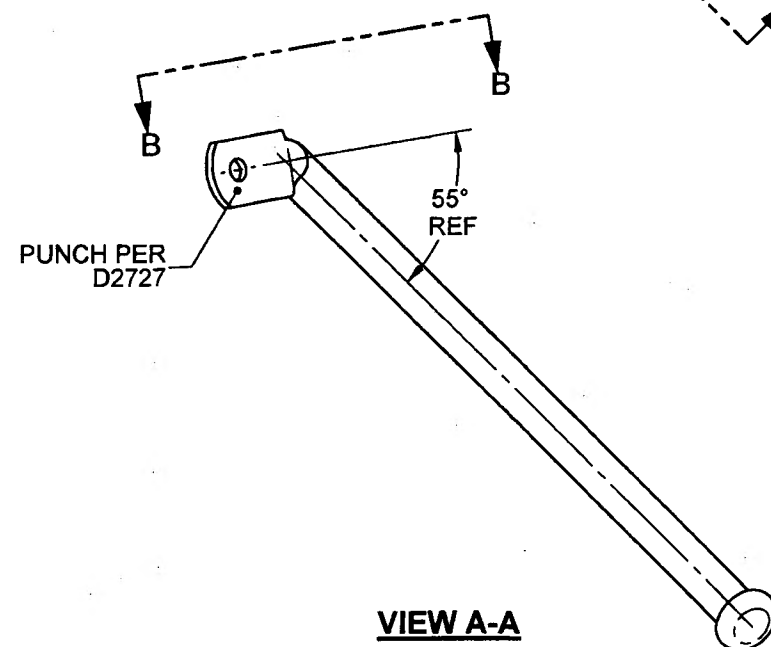
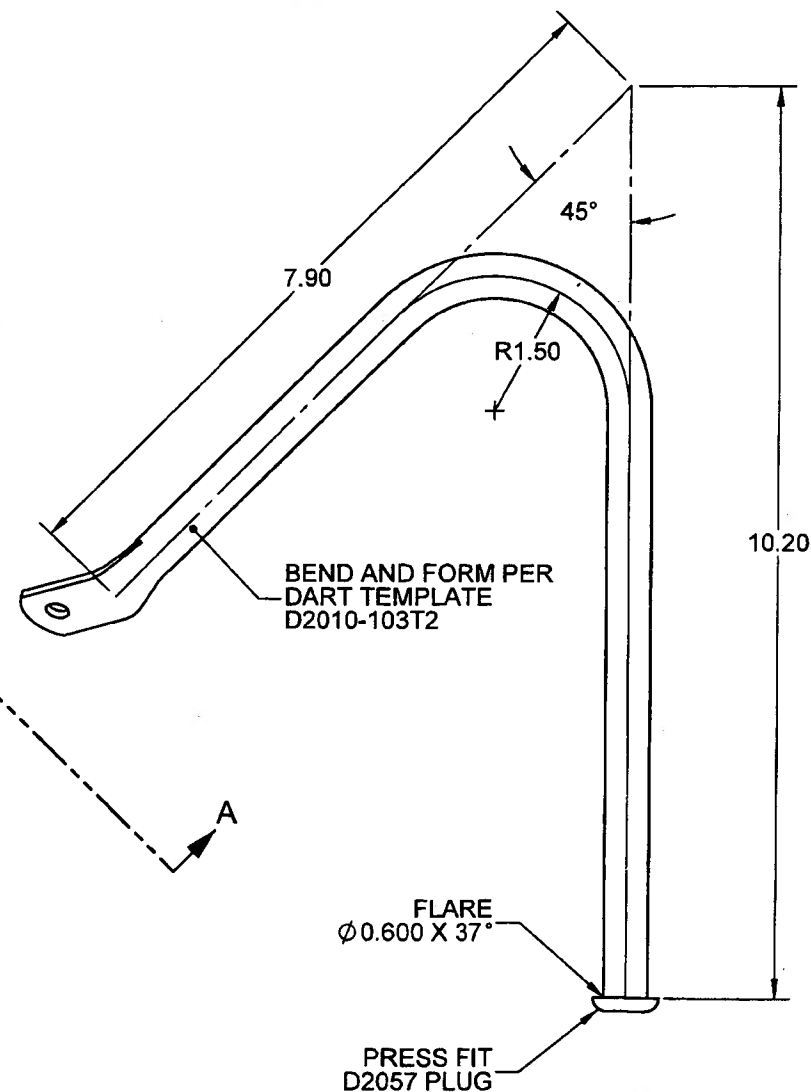
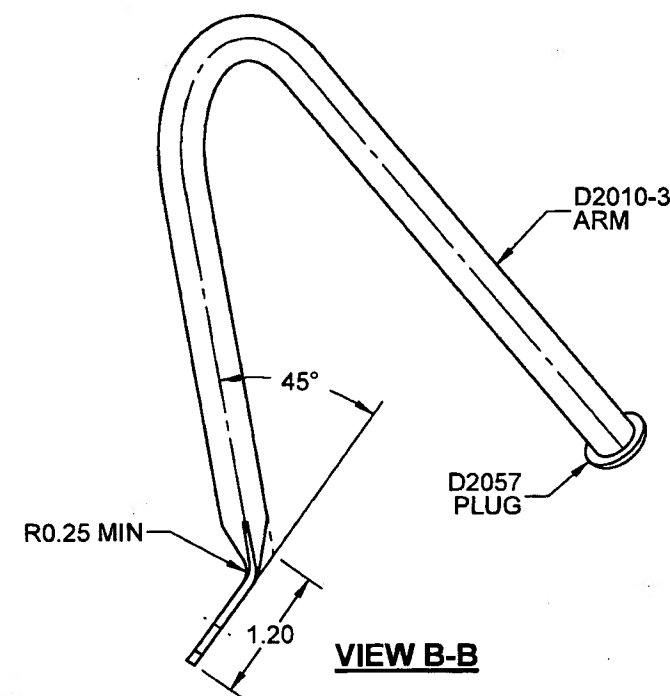
- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

RELEASED
28-06-19/11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40067

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D2010	REV. D
MFG. APPR.	JP		SHEET 2 OF 4
APPROVED	JP	TITLE MIRROR BRACKET	SCALE NTS
DE APPR.	JP		
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



D2010-103 ARM

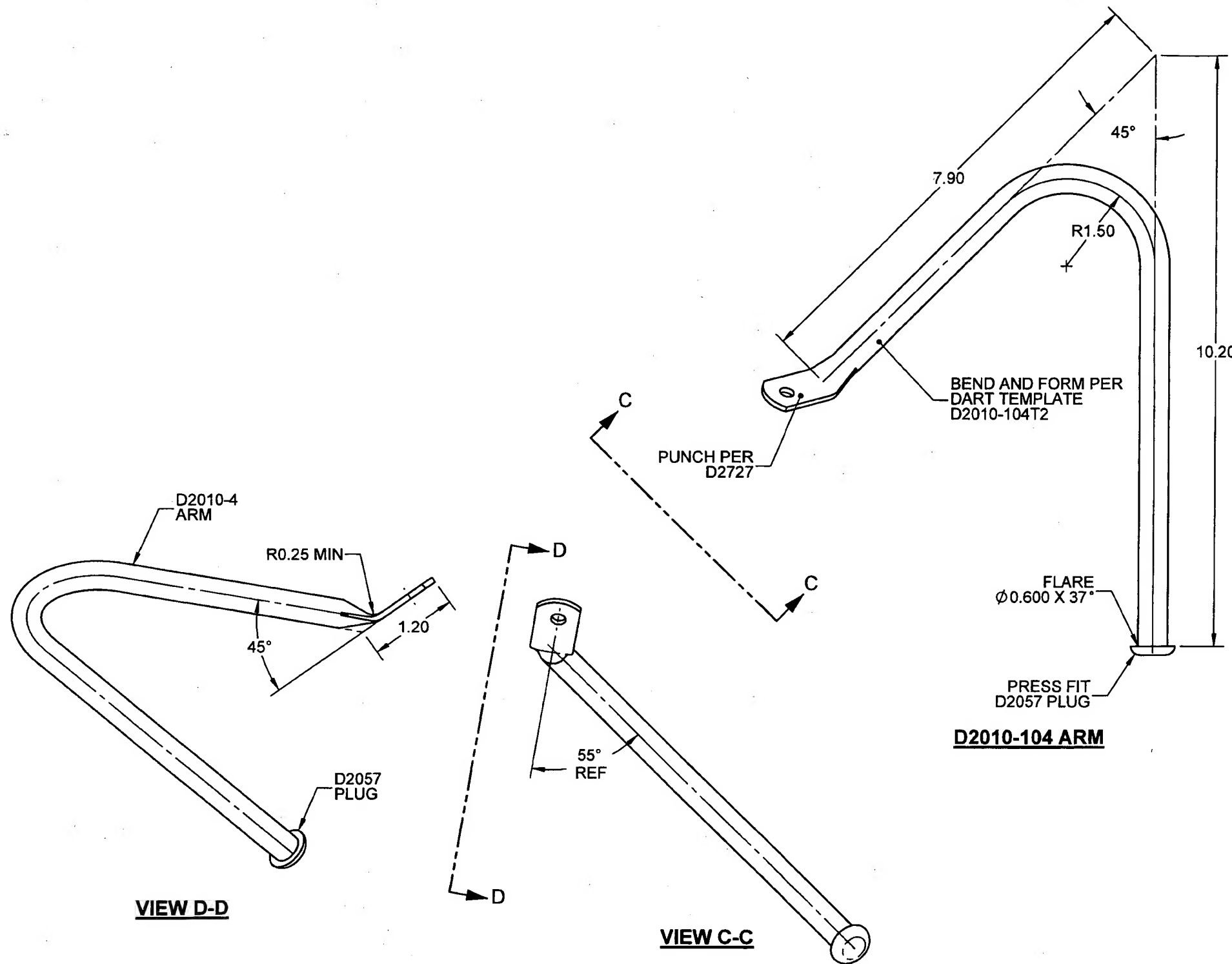
RELEASED
08-06 P/W

- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
400667

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
DATE	08.06.10	<small>COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



D2010-104 ARM

RELEASED
08-06-19-11

- NOTES:**
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING
Ø0.500 X 0.049 WALL
(REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
DATE	08.06.10	<small>COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40667

8.8
~~8.8~~
17.0625
12.
40.